

Work Order ID 67451

Monday, March 21, 2011 1:59:21 PM



Page 1

Item ID: D3852-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly

Start Date: 3/21/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

H

Date:

11-03-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3852

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- pick D3166-3 to cut D3852-2 rib (RH) as per dwg D3852 using DT9440 jig

2- drill hole (3/16") in D3852-2 using DT9439 jig and open to finish size as per dwg D3852

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D3759-1 bushing as per dwg D3852

A/R ER316 S.S. Rod Batch: *115928*

7- grind bushing weld flush as per dwg dwg D3852

8- deburr hole if necessary

340 11-04-05

(2)

Ppl 11-05-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Sulston

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulston

Quality Control

42
-042

150

Identify as per dwg & Stock Location: *PC*

0.00



Packaging

Memo

0.00

PC 11.05.05

Packaging

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/678

11-05-5
②

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, March 21, 2011 1:59:39 PM

Page 1

Work Order ID: 67451

Parent Item: D3852-042

Parent Item Name: Rib Assembly



Start Date: 3/21/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-02 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3166-3 Basket Hoop		Manufactured	No			100	Each	6.9486	0.18	0.378947			
----------------------------	--	--------------	----	--	--	-----	------	--------	------	----------	--	--	--

Location	Loc Qty	Loc Code
WA007	6.948571053	
55697	2.1053E-05	
59266	0.0418	
60270	0.00265	
61193	0.0416	
63063	0.0522	
64244	0.8103	
64928	6	

SAP 11-04-13

D3759-1 Bushing		Manufactured	No			100	Each	384.0000	1	2			
------------------------	--	--------------	----	--	--	-----	------	----------	---	---	--	--	--

Location	Loc Qty	Loc Code
WA	200	
66870	200	
WA005	184	
54072	9	
66107	42	
66489	133	

0.3790
CPL 11-03-05

(2)

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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3852-041	RIB ASSEMBLY
2		X	D3852-042	RIB ASSEMBLY
3	1	1	D3759-1	BUSHING
4	1		D3852-1	RIB
5		1	D3852-2	RIB

D3852-041 RIB ASSEMBLY

D3852-042 RIB ASSEMBLY

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.83 lbs EACH
 - 8) WELDING: PER QSI 004

SHOPEXITY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67451

011-03-21

RELEASE
08/11/07 MB

A	NEW ISSUE	MB	08.11.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.07		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3852** REV. A
SHEET 1 OF 3
TITLE **RIB ASSEMBLY** SCALE NTS

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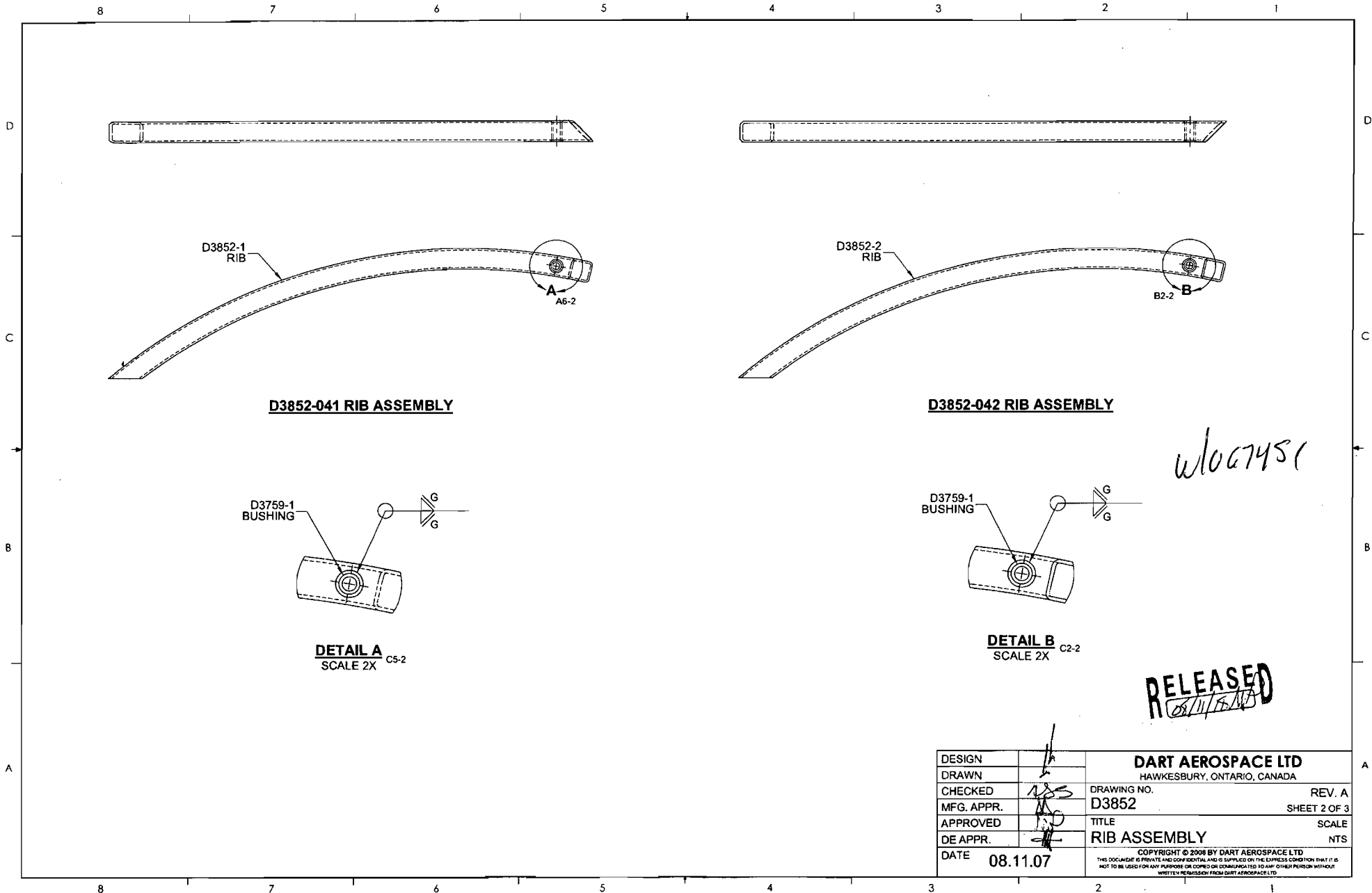
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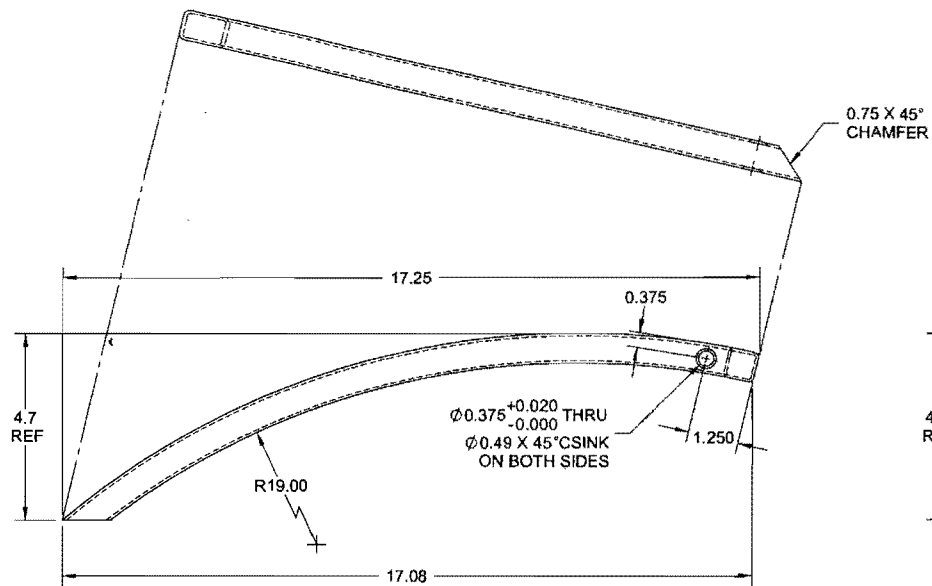
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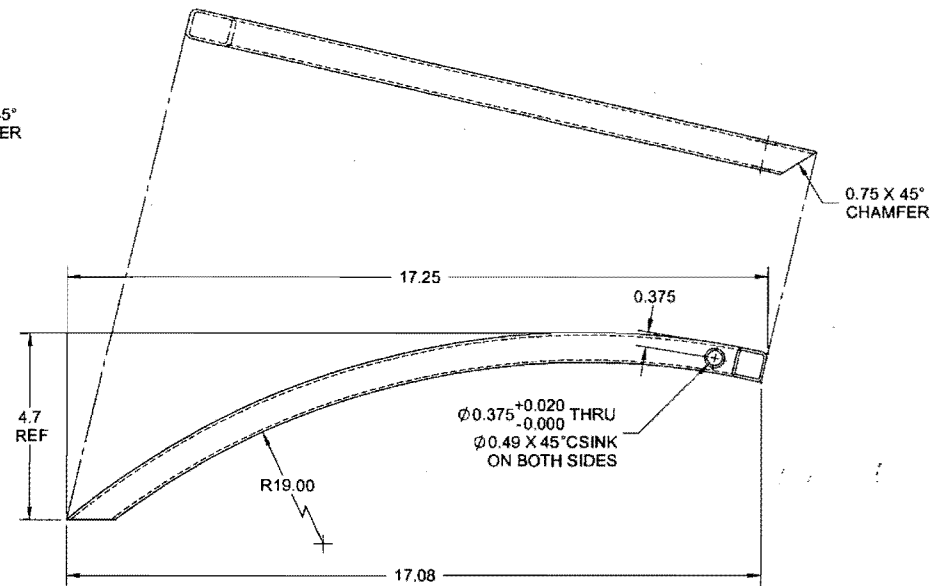
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D3852-1 RIB



D3852-2 RIB

u/b 67451

RELEASED

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs EACH

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3852	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSEMBLY	NTS
DATE	08.11.07	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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